Work Order ID 58138

April 26, 2010 11:11:13 AM

PRELIMINARY ISSUE

Item ID: D4095-043
Revision ID: PRELIM
Item Name: Wearplate Assembly

Accept

Setup Start
Stop

Start Date: 4/26/10 **Start Qty:** 2.00
Required Date: 4/26/10 **Req'd Qty:** 2.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4095	**Revision Nbr** PA3								
100	Pick Kit	0.00							
Packaging	**Memo**	0.00							
Packaging									
110		0.00							
Small Fab	**Memo**	0.00							
Small Fab	1- Bond gasket to inner surface of waerplate as per dwg A/R 3M Scotch grip adhesive Batch: M113174								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

10.04.26

100426

10.04.26

Work Order ID 58138

April 26, 2010 11:11:13 AM

Item ID: D4095-043
Revision ID: PRELIM
Item Name: Wearplate Assembly

Accept

Setup Start
Stop

Start Date: 4/26/10 **Start Qty:** 2.00
Required Date: 4/26/10 **Req'd Qty:** 2.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location:_____	0.00							
Packaging	Memo	0.00	5864						10-04-26
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/10/07

10-11-07

POSITIVE RECALL
EFFECTIVE 10-11-06 AUTH
RELEASED DATE 10.10.07

Picklist Print

April 26, 2010 11:11:12 AM

Work Order ID: 58138

Parent Item: D4095-043

Parent Item Name: Wearplate Assembly

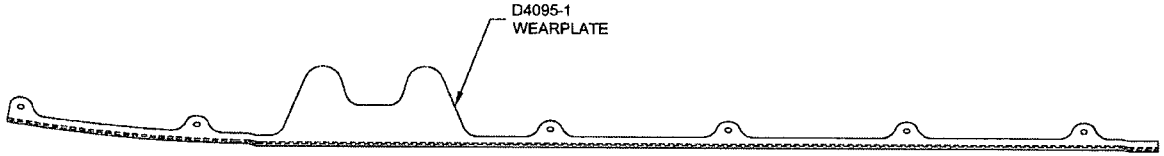
Start Date: 4/26/10 **Required Date:** 4/26/10

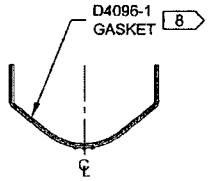
Comments: IPP Rev:A nerw issue DD 10.04.26 verified by:EC

Start Qty: 2.00 **Required Qty:** 2.00

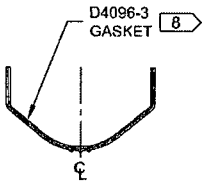
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4095-3 Wearplate		Manufactured	No	B58116		100	Each	0.0000	2.0000		100426	
D4096-3 Gasket		Manufactured	No	B58117		100	Each	0.0000	2.0000		100426	

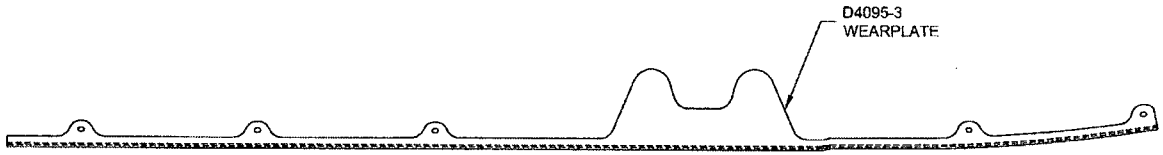
ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE





△ D4095-041 WEARPLATE ASSEMBLY





△ D4095-043 WEARPLATE ASSEMBLY

w/o 58138

PRELIMINARY ISSUE
10.04.23

D4095-041/-043 NOTES:

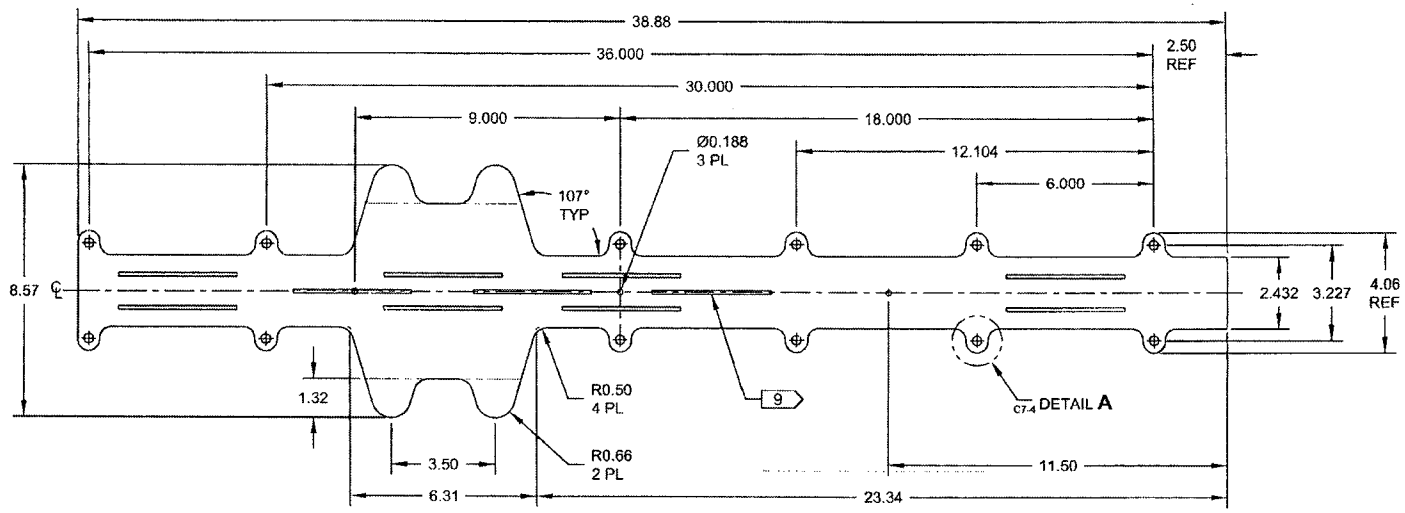
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

REV.	DESCRIPTION	BY	DATE
PA3	ADDED D4095-041/-043; 20.35 WAS 20.69 (ZN C6-3); DIM 2.80 REF WAS 2.72 (ZN B6-4)	MB	10.04.23
PA2	ADDED CLEARANCE FOR INSIDE SADDLE INCREASED EDGE DISTANCE ON SAME PROFILE	MB	10.04.22
PA1	NEW ISSUE	MB	10.04.20

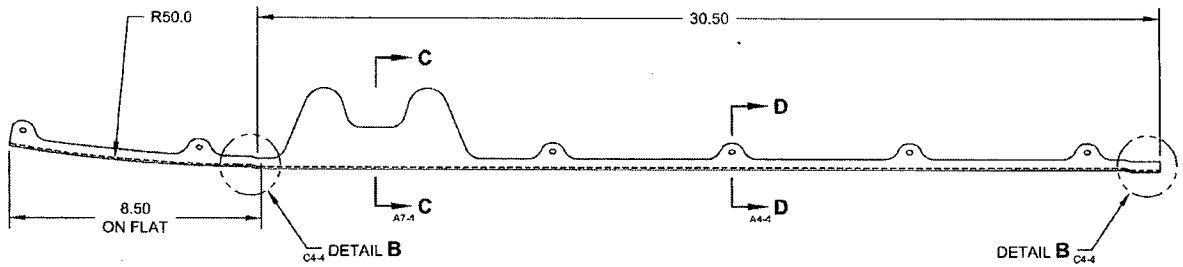
DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.04.23

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4095 — REV. PA3 — SHEET 1 OF 4
TITLE: WEARPLATE — SCALE: NTS



D4095-1F FLAT PATTERN 1



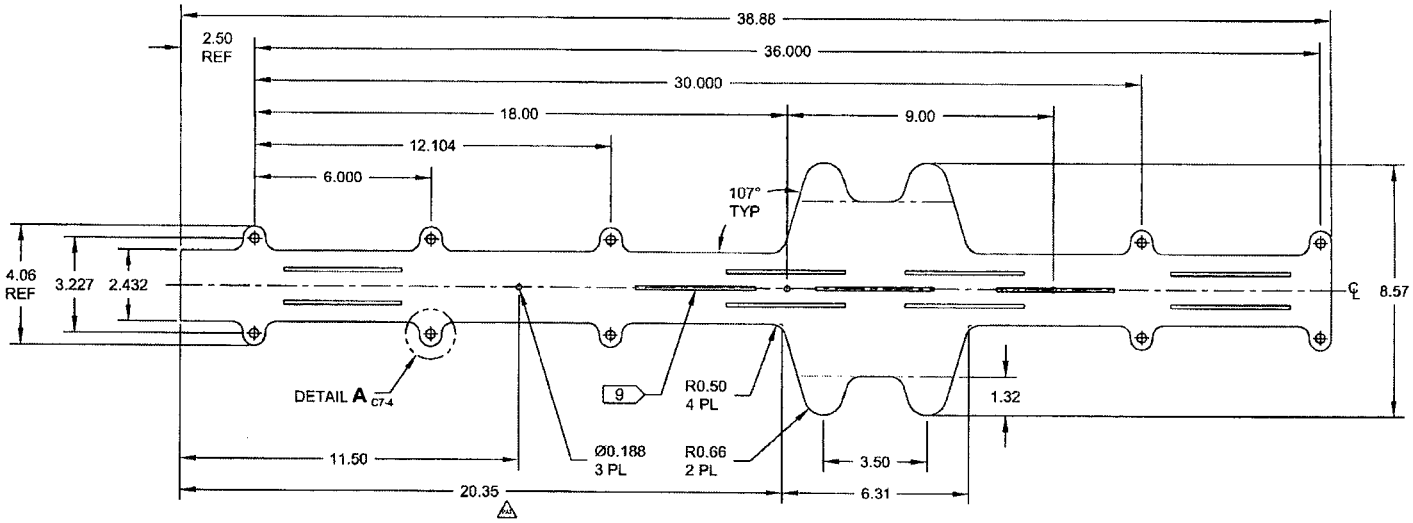
D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/-1F/-3/-3F NOTES:

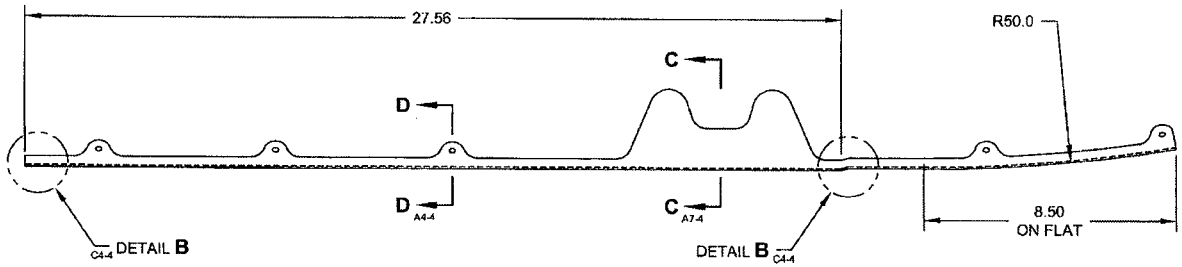
1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
   PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
   REF DART MATERIAL SPEC M304S16GA
2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
8) WELDING: PER DART QSI 004
9) 2059B HARDCOAT WELD: 4.0 LONG X 0.063 TO 0.125 HIGH, 11 PL
   WELD AFTER BENDING AS ILLUSTRATED PER DT8308

PRELIMINARY ISSUE
10.04.23

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D4095	REV. PA3 SHEET 2 OF 4
MFG. APPR.			
APPROVED		TITLE WEARPLATE	SCALE NTS
DE APPR.			
DATE	10.04.23		



D4095-3F FLAT PATTERN 1

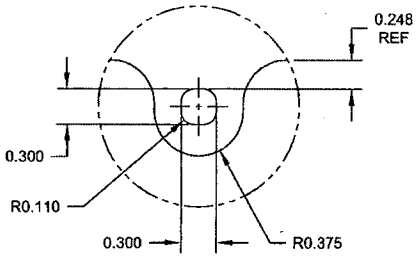


D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

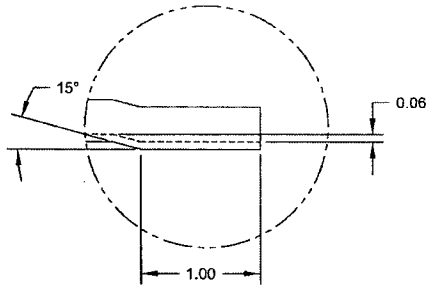
wlo 58138

PRELIMINARY ISSUE
10.04.23

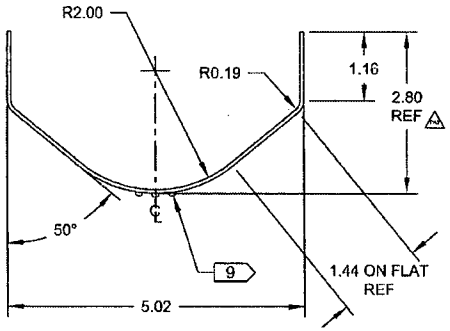
DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4095	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.23		



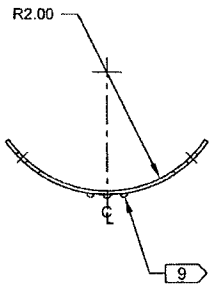
DETAIL A: TAB DETAIL
SCALE 4X C3-2 C6-3



DETAIL B: JOGGLE DETAIL
SCALE 4X B2-2 B6-2 B4-3 B7-3



SECTION C-C
SCALE 2X B5-2 B4-3



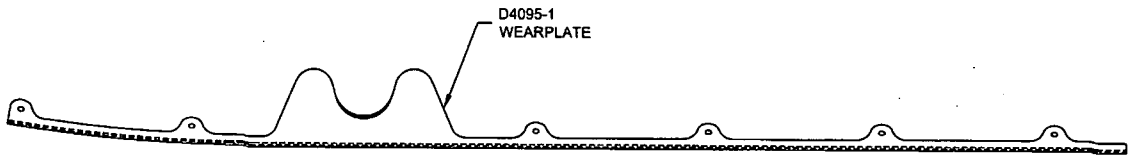
SECTION D-D
SCALE 2X

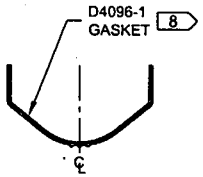
wo 58138

PRELIMINARY ISSUE
10.04.23

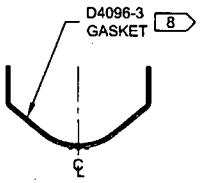
DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4095 — REV. PA3 — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE: WEARPLATE — SCALE: NTS
DE APPR.		
DATE	10.04.23	

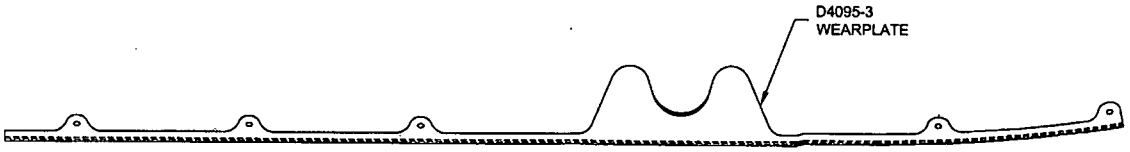
ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE





D4095-041 WEARPLATE ASSEMBLY





D4095-043 WEARPLATE ASSEMBLY

58138

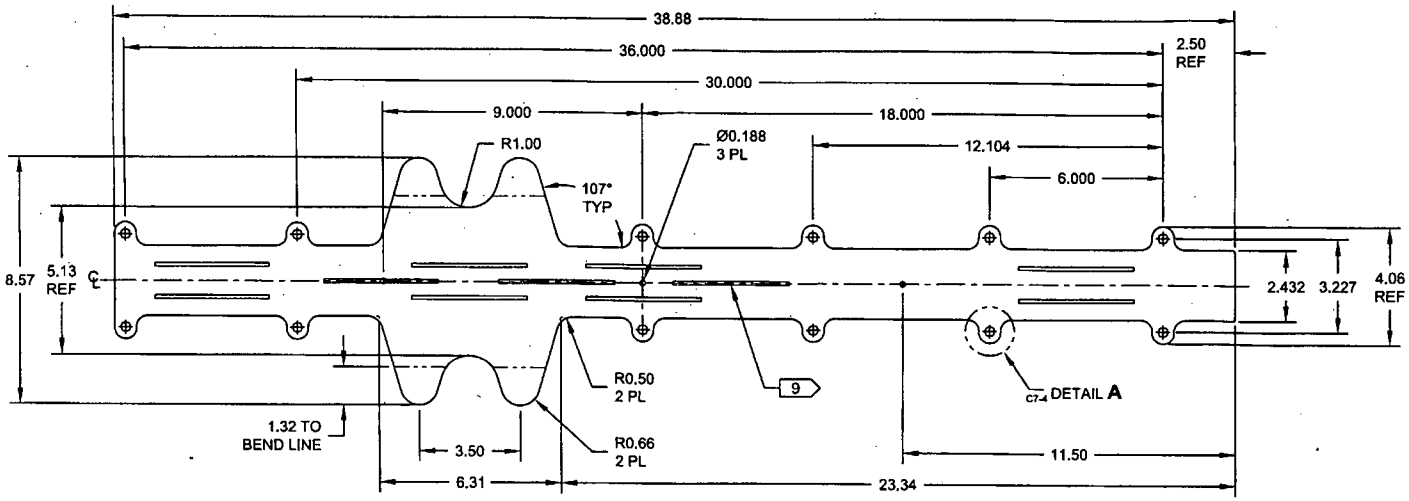
RELEASED
2010-09-07

D4095-041/-043 NOTES:

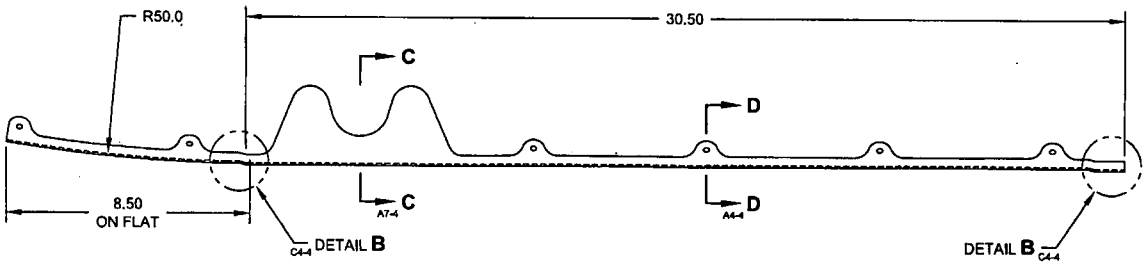
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
9) PARTS ARE SYMMETRIC ABOUT ℄

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	10.04.20

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4095	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.20		



D4095-1F FLAT PATTERN 1



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

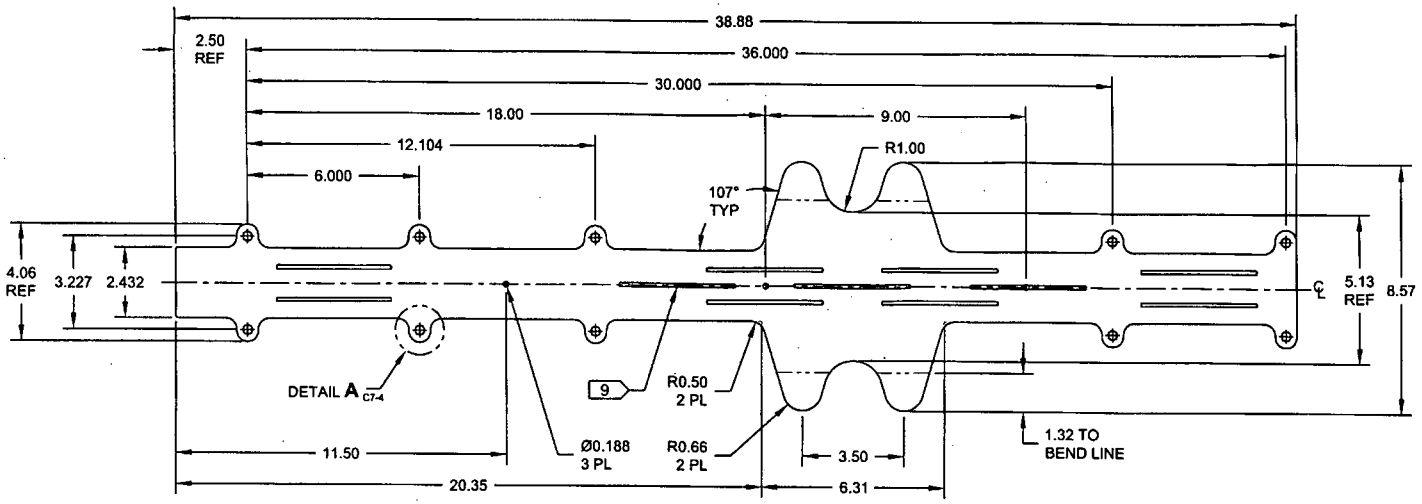
58138

RELEASED
2010-08-07

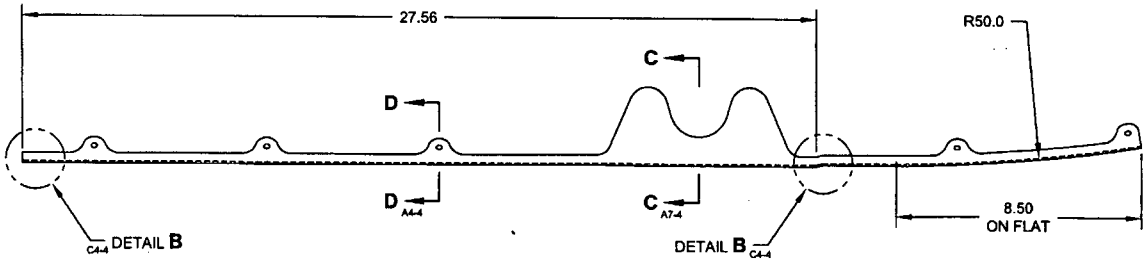
D4095-1/-1F/-3/-3F NOTES:

1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
8) WELDING: PER DART QSI 004
9) 2059B HARDCOAT WELD: 4.0 LONG X 0.063 TO 0.125 HIGH, 11 PL
WELD AFTER BENDING AS ILLUSTRATED PER DT8308
10) PARTS ARE SYMMETRIC ABOUT ℄

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4095	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.20		



D4095-3F FLAT PATTERN 1

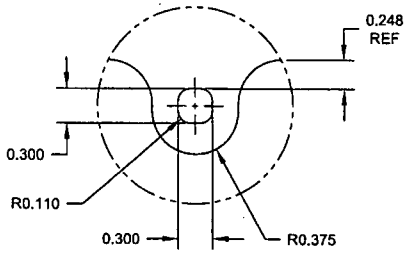


D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

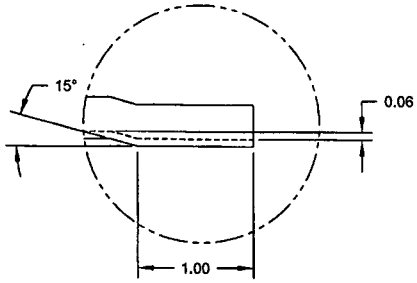
58138

RELEASED
2010 -09- 07
WMD

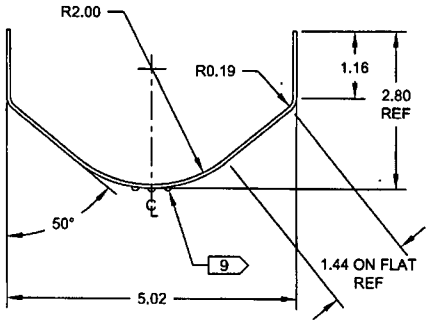
DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D4095	REV. A SHEET 3 OF 4
MFG. APPR.			
APPROVED		TITLE WEARPLATE	SCALE NTS
DE APPR.			
DATE 10.04.20			



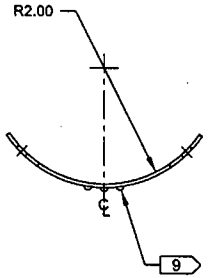
DETAIL A: TAB DETAIL
SCALE 4X C3-2 C6-3



DETAIL B: JOGGLE DETAIL
SCALE 4X B2-2 B6-2 B4-3 B7-3



SECTION C-C
SCALE 2X B5-2 B4-3



SECTION D-D
SCALE 2X

58138

RELEASED
2010-09-07

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4095 — REV. A — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE: WEARPLATE — SCALE: NTS
DE APPR.		
DATE 10.04.20		

Location/Lot Activity

October 7, 2010 1:34:21 PM

Criteria : All Items All Locations Lot: 58138 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse / Location ID	Reason	Employee ID / Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date / Lot Code	Extended Cost
Issue	D4095-043 / Wearplate Assembly	Main Warehouse	58164	FAUT01		2.0000		2.0000		
		ENG			4/27/10	-2.0000	58138	-2.0000		-$125.09
								-2.0000		**-$125.09**
WIP Receipt	D4095-043 / Wearplate Assembly	Main Warehouse	58138	FAUT01		0.0000		0.0000		
		ENG			4/27/10	2.0000	58138	2.0000		$125.09
								2.0000		**$125.09**